

Date: Thursday, 31/07/2008 12:17:55 PM
 User: Julie Lecocq

Process Sheet

| | | | | | | | |
|-----------------------|---------------------------------------|----------|------------------|------------------|-------------------------------|--|--|
| Customer | : CU-DAR001 Dart Helicopters Services | | | Drawing Name | : STRUT | | |
| Job Number | : 40845 | | | Part Number | : D2565103 | | |
| Estimate Number | : 10275 | | | Drawing Number | : D2565 REV E | | |
| P.O. Number | : | | | Project Number | : N/A | | |
| This Issue | : 31/07/2008 | S.O. No. | : | Drawing Revision | : E | | |
| Prsh Rev. | : NC | | | Material | : | | |
| First Issue | : / / | Type | : SMALL /MED FAB | Due Date | : 08/08/2008 Qty: 10 Um: Each | | |
| Previous Run | : 38028 | | | | | | |
| Written By | : | | | | | | |
| Checked & Approved By | : JUL 08-8-01 | | | | | | |
| Comment | : Est: F02.04.16 Added dwg Rev.C1 NG | | | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : | |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------|-------------------------------|--|
| 1.0 | M304TR0750W049 | 304 RD Tube .750 x .049W | |
| Comment: Qty.: 1.5934 f(s)/Unit Total : 15.9338 f(s) 304 RD TUBE .750 X.49W 304/316/318-2B Seamless Tubing, 3/4" O.D. x 0.049" wall (M304TR0750W049) Batch <u>M 108 844</u> SB 08/08/27 | | | |
| 2.0 | BRAKE NC | NC BRAKE | |
| Comment: BRAKE NC Punch to length as per Dwg D2565 using DT8313 SB 08/08/27 | | | |
| 3.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 | |
| Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Drill hole open to .316 Ø as per Dwg D2565 (one end only) <u>J</u> 08/08/28 10 AM 2-Deburr <u> </u> | | | |
| 4.0 | QC5 | INSPECT WORK TO CURRENT STEP | |
| Comment: INSPECT WORK TO CURRENT STEP <u>S 08/08/28 10 AM</u> | | | |
| 5.0 | POWDER COATING | POWDER COATING | |
| Comment: POWDER COATING Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3 START TIME: <u>1:50 PM</u> OVEN TEMPERATURE: <u>400</u> FINISH TIME: <u>2:20</u> m/a 08/09/02 | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 31/07/2008 12:17:55 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 40845

Part Number: D2565103

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|-----|-----------------------------------------|
| 6.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION |
|-----|-----|-----------------------------------------|



SL



Comment: INSPECT POWDER COAT

08-09-03 (J)

| | | |
|-----|-------------|-----------------------|
| 7.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 270

AS 08/09/03

(XO)

| | | |
|-----|------|------------------------------|
| 8.0 | QC21 | FINAL INSPECTION/W/O RELEASE |
|-----|------|------------------------------|



Comment: FINAL INSPECTION/W/O RELEASE

MF 08-09-03

Job Completion



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D2565-103 PAR #: N/A Fault Category: Prod / Finishing NCR: Yes No DQA: D Date: 08/05/05
 D205-633 QA: N/C Closed: D Date: 08/09/05

| NCR: 40845 | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------------|------|----------------------------------------------------------------------------------------------------------|-----------------------------|------------------------------------------------------------------|----------------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 8/9/05 | 6.0 | on three struts it was found with ink from the nut. showing through the Powder coat. only in small areas | JOSIMUZ | sand all three with 320 grit sand paper. and clean with acetone. | HL 08/09/05 +3 | S 08/09/05 | JASIMUZ | S 08/09/05 |
| | | | JOSIMUZ | Re powder coat as per QSI 2005 | HL 08/09/05 ③ | S 08/09/05 | JASIMUZ | S 08/09/05 |
| | | | | | | | | |

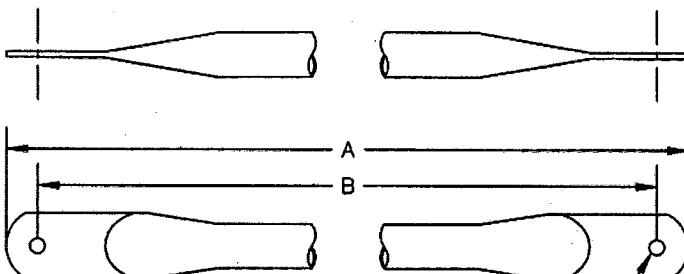
NOTE: Date & initial all entries

DART

| | | | |
|----------|----------|---------------------------------------------------|--------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. | REV. E |
| | | D2565 | SHEET 1 OF 1 |
| DATE | | TITLE | SCALE |
| 04.05.05 | | STRUT | 1:3 |

RELEASED

04.05.05



DIA 0.257 TO BE PUNCHED
 "C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2638

| PART # | A | B | DIA C |
|-----------|-------|-------|-------|
| D2565-101 | 20.52 | 19.72 | 0.316 |
| D2565-103 | 18.21 | 17.41 | 0.316 |
| D2565-105 | 20.19 | 19.39 | 0.316 |
| D2565-107 | 13.43 | 12.63 | — |
| D2565-109 | 12.31 | 11.51 | — |
| D2565-111 | 13.65 | 12.85 | — |
| | | | |
| D2565-201 | 22.79 | 22.00 | 0.316 |
| D2565-203 | 20.75 | 19.95 | 0.316 |
| D2565-205 | 21.22 | 20.42 | 0.316 |
| D2565-207 | 16.07 | 15.27 | — |
| D2565-209 | 15.16 | 14.36 | — |
| D2565-211 | 14.14 | 13.34 | — |
| | | | |
| D2565-301 | 27.03 | 26.23 | 0.316 |
| D2565-303 | 25.34 | 24.54 | 0.316 |
| D2565-305 | 23.73 | 22.93 | 0.316 |
| D2565-307 | 20.86 | 20.06 | — |
| D2565-309 | 20.17 | 19.37 | — |
| D2565-311 | 16.30 | 15.50 | — |
| | | | |
| D2565-401 | 18.29 | 17.49 | 0.316 |
| D2565-403 | 15.64 | 14.84 | 0.316 |
| D2565-405 | 19.45 | 18.65 | 0.316 |
| D2565-407 | 10.79 | 9.99 | — |
| D2565-409 | 9.34 | 8.54 | — |
| D2565-411 | 13.81 | 13.01 | — |

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
 (REF DART SPEC. M304TR0.750W0.049)
 ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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 WORK ORDER
 NO. *10865*